

1   **Abstract**

2   This invention relates to a stabilized phenolic resole resin composition comprising a  
3   phenolic resole resin and an effective stabilizing amount of an ortho ester. The invention  
4   also relates to phenolic urethane binders prepared with the phenolic resole resin  
5   compositions, and the use of the binders to make foundry mixes, foundry shapes, and  
6   metal castings.